

Work Order ID 78828

78828

Page 1

January-16-12 1:06:15 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 16/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/16 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

0.00

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

S. L. L. L. L.

for M.L.J 12-2-14

B78828 L+1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78828***78828***

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Required Date: 30/01/2012 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

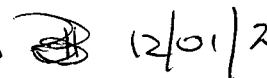
6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)



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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-011

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 15/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: *M119712* *ZE* *12-01-23*

12-Grind welds flush as per Dwg D2750 — *ND/CF* *12-1-23*

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo 0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo 0.00

Quality Control

① *②* *③* *12-1-23*

⑤ *12/1/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 16/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

① ~~CF~~ 12-1-29

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

② 12-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: M119999
exp. date: 2012-08-138- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)A/R Aluminum Rod batch: M119712

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 12/01/27

> CF 12-1-27

{ BE 12-02-02

BB 12/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NS2***

Item Name: Skidtube LH

Start Date: 16/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

> BB 12/02/06

S 12/02/07

S 12/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 78828

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January-16-12 1:06:15 PM

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH

Start Date: 16/01/2012 Start Qty: 1.00

1

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Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 12/02/08

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-10
320°F
10-40

0.00

210

QC3- Inspect Part Finish

0.00

210

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

1X2 M/L 12/02/08

1 12/02/09

muayd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 78828

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January-16-12 1:06:15 PM

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NS1

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Start Date: 16/01/2012 Start Qty: 1.00

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Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

1 LH / 12/02/09

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 1010

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11119508

EXP DATE: 12/08

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 11110348

5-Coat all exposed fasteners with "LPS Procyon" batch: 11114596

0.00

0.00

1 LH / 12/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January-16-12 1:06:15 PM

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Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube LH

Start Date: 16/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240 QC5- Inspect part completeness to step on W/O 0.00

240

QC

Memo

0.00

Quality Control

250 Pick Kit 0.00

250

Packaging

Memo

0.00

Packaging

260 QC4- 100% Inspect kits for completeness 0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

8/26/10

① SP 12-02-15

①

W/O:		WORK ORDER CHANGES					
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Work Order ID 78828

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January-16-12 1:06:15 PM

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH

Start Date: 16/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

Rev I

FG072

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/2/16

12/2/17
MF
12-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	110.0000	8	8			
D3492-1									**				
Plug													

Location	Loc Qty	Loc Code
FP002	110	
69531	8	
74444	2	
76235	100	

D3492-3		Manufactured	No			230	Each	5.0000	8	8			
D3492-3									**				
Plug													

Location	Loc Qty	Loc Code
FP002	5	
74871	5	

Handwritten notes: ** 12/02/09, 1377039 (x8) 12/02/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

163.0000

8

8

NAS1611-010

O-RING

**

12/02/09

Location

Loc Qty

Loc Code

FP

90

110915

0

120121

90

FP001

73

110915

14

117460

8

118077

1

118612

3

119438

47

NAS1149D0863J

Purchased

No

250

Each

155.0000

2

2

NAS1149D0863.J

WASHER

**

12-02-15

Location

Loc Qty

Loc Code

ST298

155

118078

55

119307

100

D2744

Manufactured

No

110

Each

30.0000

1

1

D2744

Cap

**

12-01-23

Location

Loc Qty

Loc Code

LG002

30

62715

1

70881

12

71861

17

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78828

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

16.0000

1

D2600-3-BENT

Extrusion Bent

**

12/01/21

Location

Loc Qty

Loc Code

LG

16

66875

7

73253

1

75021

1

75022

1

75023

1

77623

5

D2743

Manufactured No

160 Each

121.0000

8

8

D2743

Crossbolt Spacer

**

*BE 12-02-02
B 78603 *8*

Location

Loc Qty

Loc Code

LG001

121

67766

4

68251

3

73403

64

74445

50

D2739

Manufactured No

160 Each

7.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG

7

72155

1

77621

2

78420

4

B 788918

1

CF 12-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No 160 Each 38.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE 12-02-02

Location Loc Qty Loc Code

LG001 38

77567 38

D3490-1 Manufactured No 160 Each 46.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 12-02-02

Location Loc Qty Loc Code

LG001 46

62450 2

74875 4

77042 40

ALS4-1032-225 Purchased No 220 Each 978.0000 38 38

ALS4-1032-225

Insert

**

M1120451 (x38) M 12/01/09

Location Loc Qty Loc Code

ST281 978

108696 199

110768 62

118386 649

118966 68

D3793-3 Manufactured No 230 Each 11.0000 1 1

D3793-3

Wearshoe

**

D37935(x1) M 12/01/09

Location Loc Qty Loc Code

FP001 11

75043 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

78.0000

1

1

AN8C35A

BOLT

**

u 12/02/09

Location

Loc Qty

Loc Code

FP002

77

115960

1

117834

20

118286

56

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

20.0000

1

1

D3793-1

Wearshoe

**

u 12/02/09

Location

Loc Qty

Loc Code

FP001

20

75038

7

77029

13

D3488-041

Manufactured

No

230

Each

12.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

u 12/02/09

Location

Loc Qty

Loc Code

FP002

12

61689

1

69903

2

75056

9

xi

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

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Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

10.0000

1

1

D3794-3

Gasket

B78895 (x1) 14/12/09

LocationLoc QtyLoc Code

FP002

10

74530

2

74596

8

AN6C44A

Purchased No

230

Each

68.0000

4

4

AN6C44A

BOLT

M120465 (x4) 14/12/09

LocationLoc QtyLoc Code

FG

2

103964

2

ST343

66

119125

21

120095

20

120143

25

MS21083C8

Purchased No

230

Each

83.0000

1

1

MS21083C8

NUT

14/12/09

LocationLoc QtyLoc Code

FP002

1

115884

1

ST303

32

115884

0

118077

1

118614

4

119309

2

119436

23

119638

2

ST304

50

120142

50

x1

January-16-12 1:06:20 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-16-12 1:06:20 PM

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket

**

B 78902 (x1) JH 12/02/09

Location

Loc Qty

Loc Code

FP002

15

75039

15

D3631-1

Manufactured No

230

Each

327.0000

8

8

D3631-1

Washer

**

JH 12/02/09

Location

Loc Qty

Loc Code

ST072

327

68062

2

75548

325

D3791-1

Manufactured No

230

Each

18.0000

1

1

D3791-1

Wearplate

**

JH 12/02/09

Location

Loc Qty

Loc Code

FP002

18

62239

2

75041

16

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

***AN960C10L ***

washer

**

1119736 (x38) JH 12/02/09

D2745

Manufactured No

230

Each

65.0000

8

8

D2745

Bushing

**

1378597 (x8) JH 12/02/09

Location

Loc Qty

Loc Code

FP001

65

69529

1

76142

64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

768.0000

34

34

AN3C5A

Bolt

**

34 12/02/09

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

761

116419

28

117343

17

117764

37

117872

2

119127

500

119749

177

x34

D3537-1

Manufactured

No

230

Each

50.0000

3

3

D3537-1

Wearpad

**

B78591 (x3) 12/02/09

Location

Loc Qty

Loc Code

FP002

50

69817

5

77036

45

NAS1149C0832R

Purchased

No

230

Each

317.0000

1

1

NAS1149C0832R

WASHER

**

34 12/02/09

Location

Loc Qty

Loc Code

ST297

317

114915

317

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

178.0000

4

4

AN3C6A

BOLT

**

M120423 (x4) Jul 12/02/09

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

177

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

99

119749

10

NAS1611-013

Purchased

No

230

Each

180.0000

8

8

NAS1611-013

O-RING

**

M120360 (x8) Jul 12/02/09

Location

Loc Qty

Loc Code

FP

84

117291

0

120121

84

FP001

96

116582

5

117291

2

117887

53

119623

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

25.0000

1

1

D3535-25

Wearshoe

**

12/02/09

Location

Loc Qty

Loc Code

FP001

13

62233

1

75040

12

FP002

12

77617

12

D3794-1

Manufactured No

230

Each

28.0000

1

1

D3794-1

Gasket

**

12/02/09

Location

Loc Qty

Loc Code

FP002

28

75042

28

MS21043-6

Purchased No

230

Each

365.0000

4

4

MS21043-6

NUT

**

12/02/09

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

345

112314

135

117887

10

118384

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

51.0000

2

2

**

SP

8 *D3493-1*
Washer

Location

Loc Qty

Loc Code

ST050

51

70697

2

76237

9

77573

40

2x

MS21083C8

Purchased No

250 Each

83.0000

2

2

**

SP

8 *MS21083C8*
NUT

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

32

115884

0

118077

1

118614

4

119309

2

119436

23

119638

2

ST304

50

120142

50

2x

AN8C21A

Purchased No

250 Each

75.0000

2

2

**

SP 12-02-15

AN8C21A
BOLT

Location

Loc Qty

Loc Code

ST343

75

118758

5

119530

20

120094

50

2x

January-16-12 1:06:20 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 78828

78828

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

171.0000

4

4

***NAS1515H3I ***

WASHER

**

12/02/09

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

131

118686

3

119438

28

120072

100

x4

D2741

Manufactured

No

250

Each

14.0000

1

1

D2741

Blade, 350 Skidtube

**

SP. 12-02-15

Location

Loc Qty

Loc Code

ST

-10

ST466

24

71856

14

14

D3532-1

Manufactured

No

250

Each

16.0000

2

2

D3532-1

Spacer

**

B78839

SP 12-02-15

Location

Loc Qty

Loc Code

ST054

16

74880

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHIP
R
UNCO
SUB
W
NO. 78828 H.C.J.
12/01/16

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

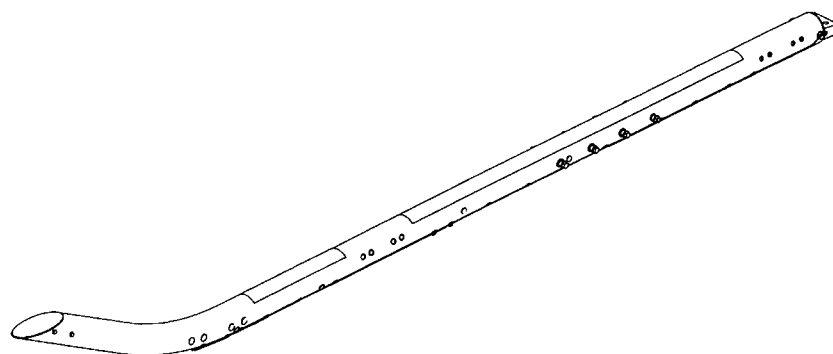
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

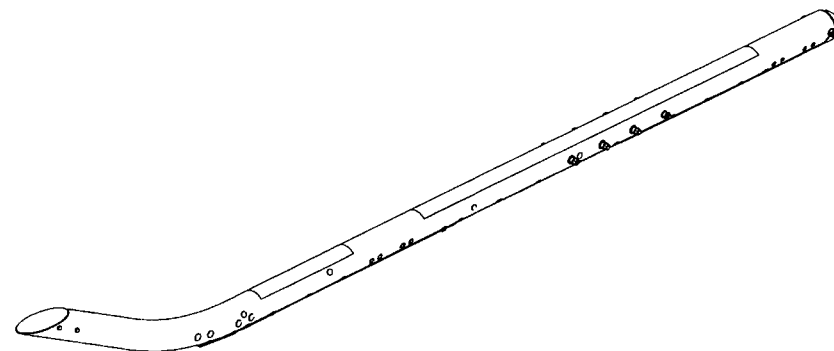
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78828



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-09-22/11

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

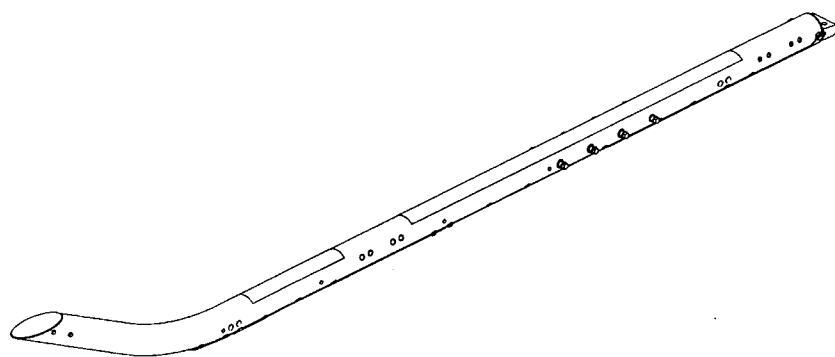
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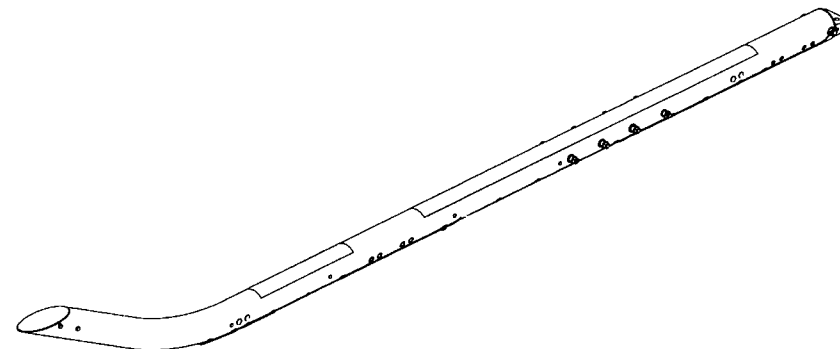
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78828



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-22-1-11

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

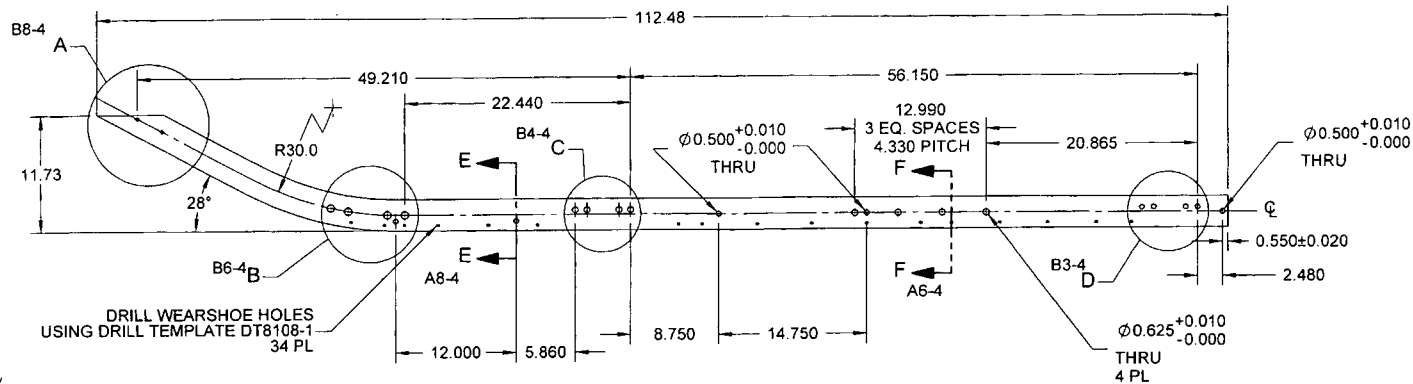
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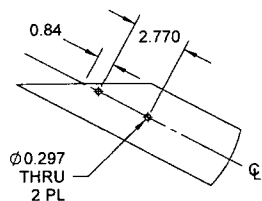
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

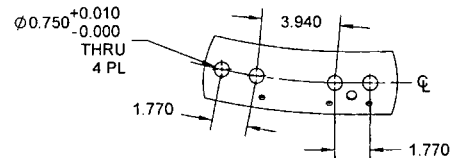
78828



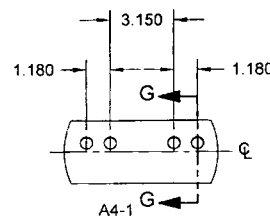
D2750-1 LH SKIDTUBE



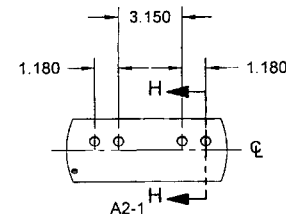
DETAIL A
SCALE 2X



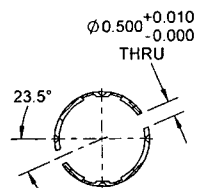
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SCALE 2X



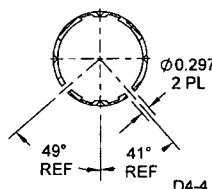
DETAIL C
SCALE 2X



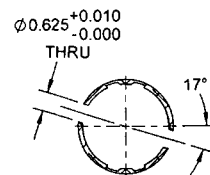
DETAIL D
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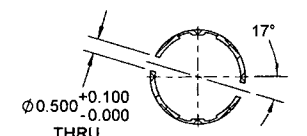
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	IP	DART AEROSPACE USA, INC.	
DRAWN	IP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

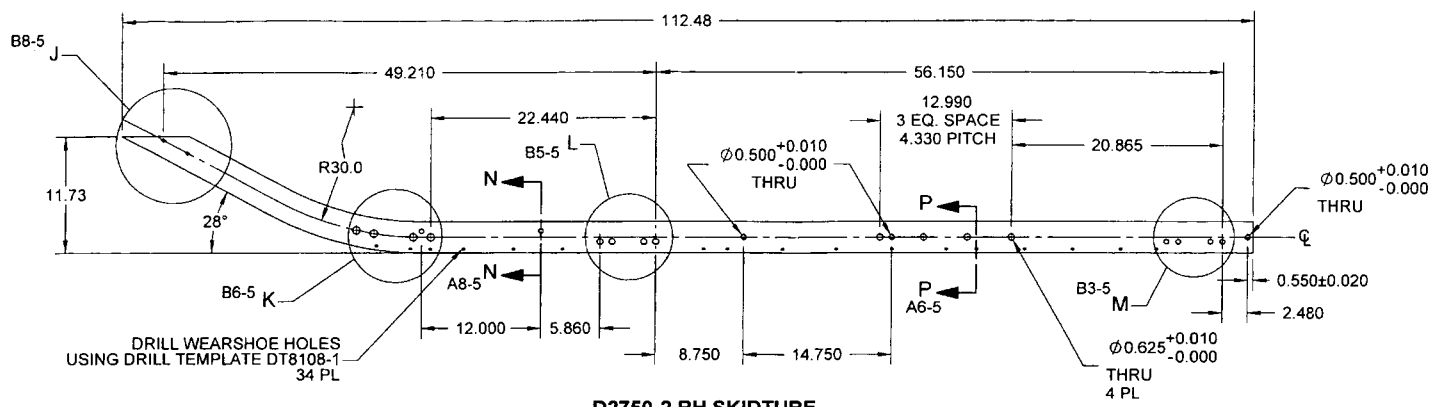
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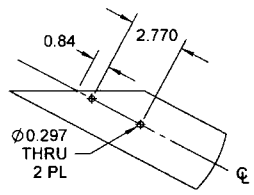
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

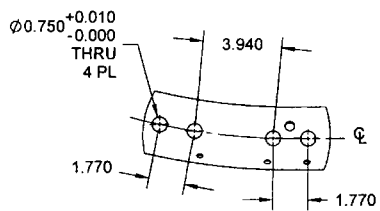
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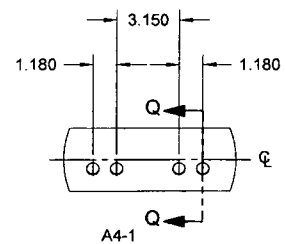
D2750-2 RH SKIDTUBE



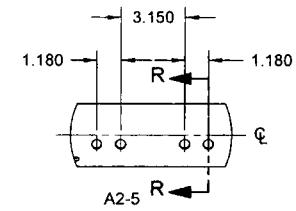
DETAIL J
SCALE 2X



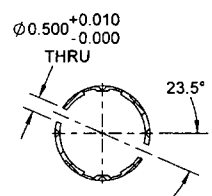
DETAIL K
SCALE 2X



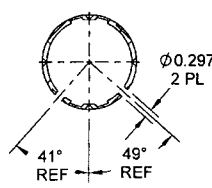
DETAIL L
SCALE 2X



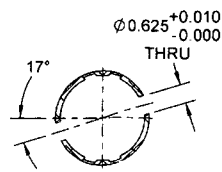
DETAIL M
SCALE 2X



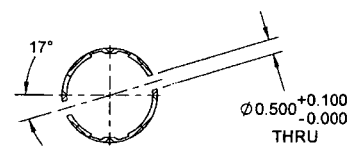
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

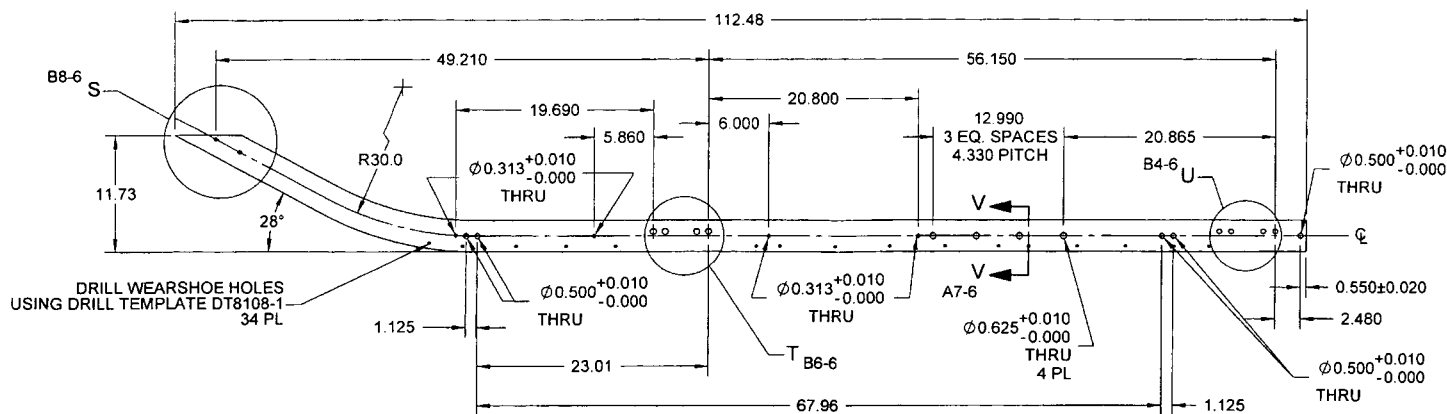
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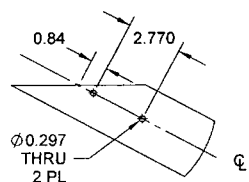
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

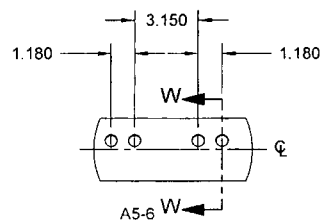
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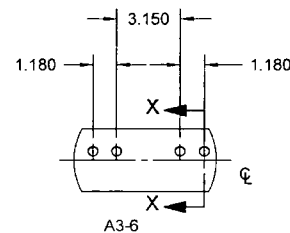
D2750-3 LH SKIDTUBE



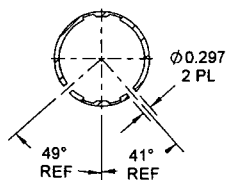
DETAIL S
SCALE 2X



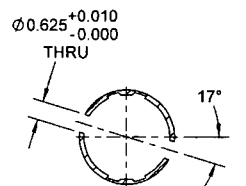
DETAIL T
SCALE 2X



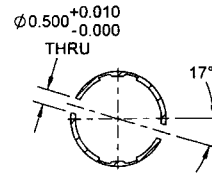
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

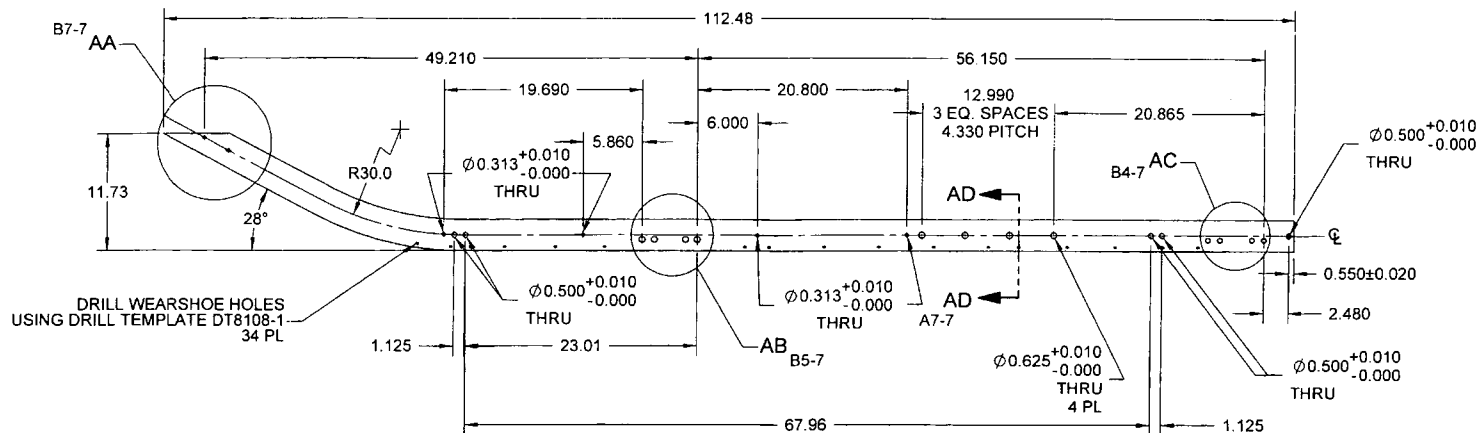
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

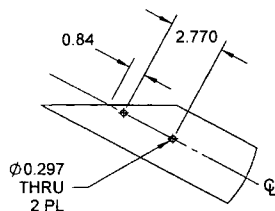
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

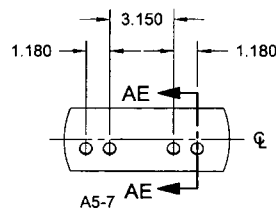
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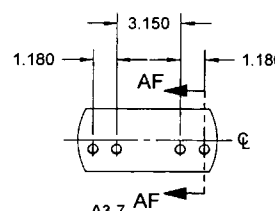
D2750-4 RH SKIDTUBE



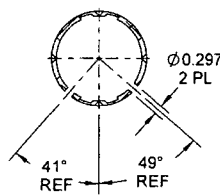
DETAIL AA
SCALE 2X



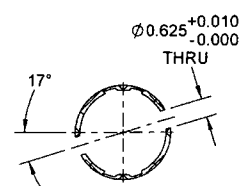
DETAIL AB
SCALE 2X



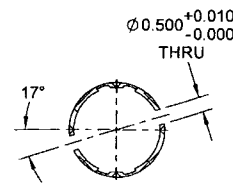
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED

DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 7 OF 11
APPROVED	REV. F	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



D8-8
RELEASED
05-09-22 / 104

DESIGN	<i>BA</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>BA</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

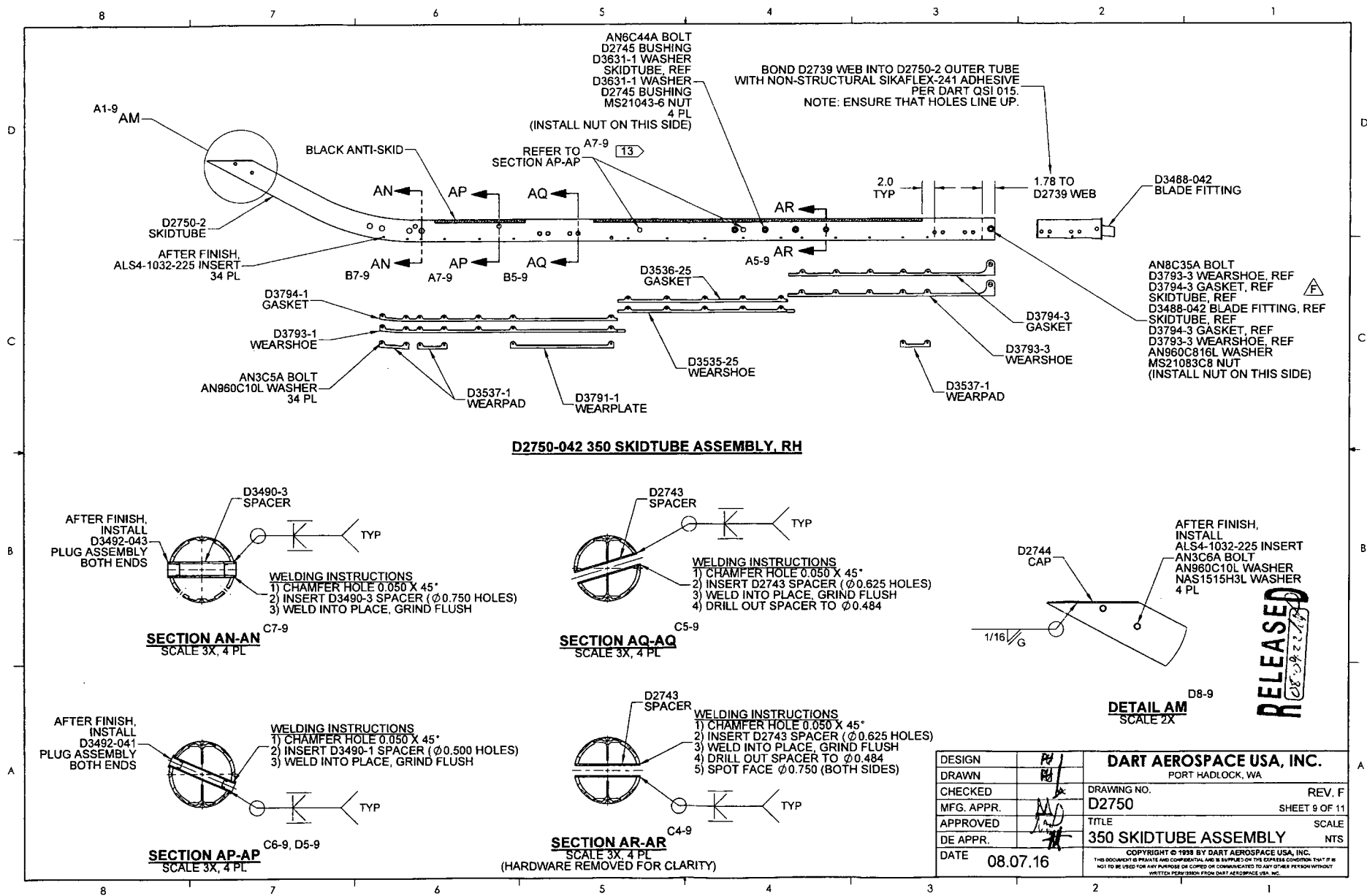
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78828



DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

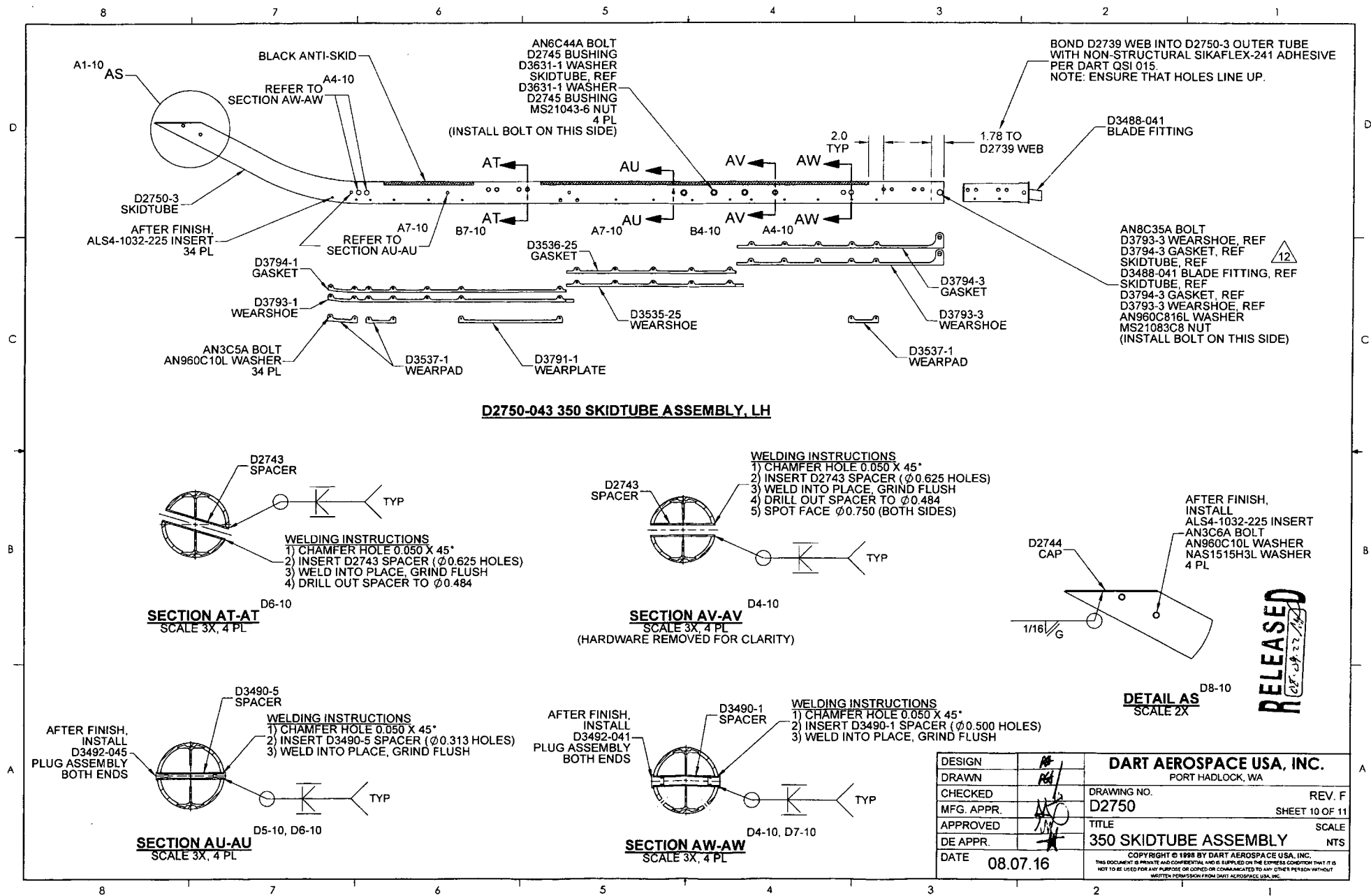
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78829



DESIGN	AS RGT	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

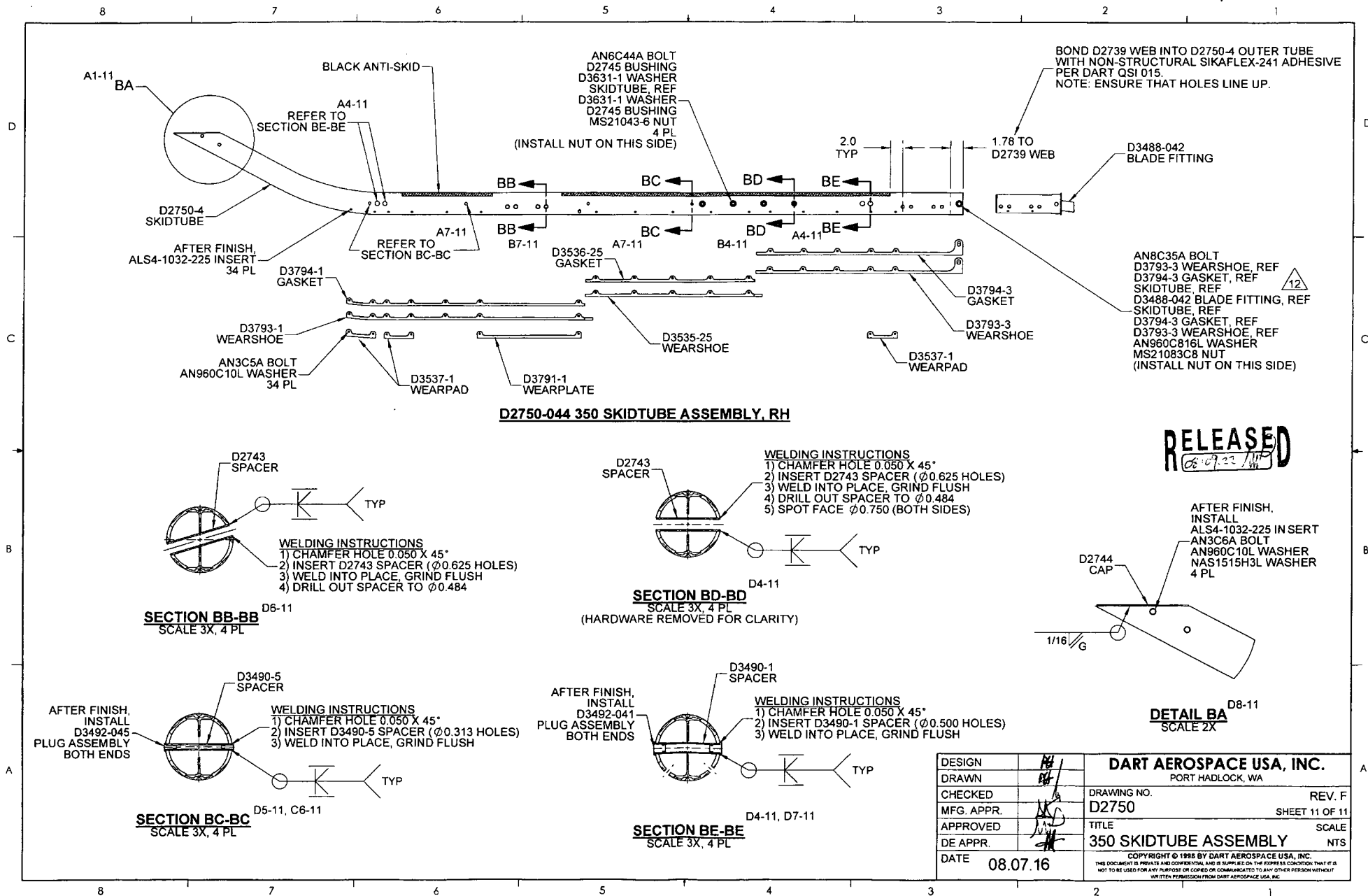
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78870



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 282

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 78413
Part number: A350-636-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Newell Date of Test Coupon 12.02.01
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld